

Date: Monday, 6/12/2006 3:36:37 PM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: FWD MOUNTING LUG
Job Number	: 27502		
Estimate Number	: 10454		
P.O. Number	: N/A	Part Number	: D26161
This Issue	: 6/12/2006	Drawing Number	: D2616 REV D3
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A	Drawing Revision	: D3
Previous Run	: N/A	Material	: N/A
Written By	:	Due Date	: 7/30/2006
Checked & Approved By	: <u>KA</u> 06.06.13	Qty:	100
Comment	: Est Rev: 06.06.22 Removed P/O for powder coat EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M6061T6B1000X02000	6061-T6 Bar 1.0" x 2.0"	
		Comment: Qty.: 0.1749 f(s)/Unit Total : 17.4930 f(s) Material: 6061-T6 QQ-A-200/8 2" X 1" Bar Batch: M101000	<i>Tnk 06/06/24 100</i>
2.0	BAND SAW	BAND SAW	
		Comment: BAND SAW Cut blanks: 2.000" long +0.030" -0.000"	<i>Tnk 06/06/24 100</i>
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
		Comment: HAAS CNC VERTICAL MACHINING #1	
		1-Machine as per folio D2616-1 & DWG D2616	
		2-Tumble & Deburr	<i>Tnk 06/06/24 100</i>
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	<i>Tnk 06/06/26 100</i>
5.0	QC8	SECOND CHECK	
		Comment: SECOND CHECK	<i>Er 06/06/29 100</i>

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries QA: N/C Closed: _____ Date: _____

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Process Sheet

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Job Number: 27502

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Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

a.m 06-06-29 (100)

7.0 POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

Note: Mask large hole

DL 06/07/05 (100)

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FC 06 07 08 (100)

9.0 D2611

Bearing



Comment: Qty.: 1.0000 Each(s)/Unit Total : 100.0000 Each(s)

Pick:

Qty Part Number Description Batch 68X27525
1 D2611 Bearing 32 B25009

SB 06/07/19 (100)

10.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Coat bearing in light oil

2-Press Bearing in D2616-2

3-Stack as per Dwg D2616 using DT8019

4- Touch up paint if required

SB 06/07/19 (100)

11.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

99

100

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
06-07-15	10.0	Part strip seal. bearing was pressed. The cookled damaged the bearing in the part.	B QSI12	destroy.	QA0 06-07-18	/	B QSI12 06-07-15	/

Part No: _____

PAR #: _____

Fault Category: _____

NCR: Yes

 NoDQA: DDate: 06/09/11

NOTE: Date & initial all entries

QA: N/C Closed: _____

Date: _____

Date: Monday, 6/12/2006 3:36:38 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FWD MOUNTING LUG

Job Number: 27502

Part Number: D26161

Job Number:



Seq. #: Machine Or Operation:

Description :

12.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: S193

Ref/8/11 (94)

13.0 DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

(92) Doc/08/11

Job Completion



U 3689.11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

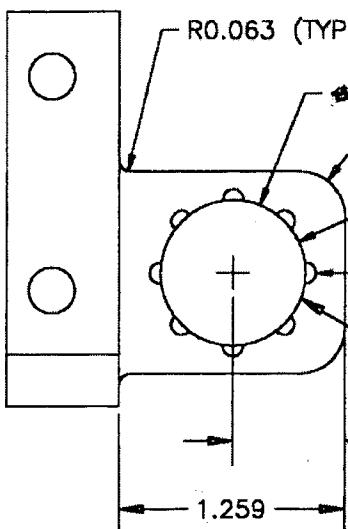
NOTE: Date & initial all entries QA: N/C Closed: _____ Date: _____



1 COPY ISSUED
BY DART

DESIGN	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. D
	BW	D2616	SHEET 1 OF 1
DATE		TITLE	SCALE
97.07.31		FWD MOUNT LUG	1:1
D1	99.12.16	STAKE 4 PLATES INSTEAD OF 8 PLATES/SIDE	A 96.10.20 ORIGINAL ISSUE
D2	00.11.21	CHG. HOLE TOL. PER NCR 449.	B 97.05.06 RE-DESIGN
D3	02.04.70	ADD STAKING NOTE PER CAR 107	C 97.06.04 REMOVE D2616-3
		D 97.07.31 D2611 WAS CBA-6-B2	

VIEW A-A



R0.063 (TYP)
R0.250 (TYP)

PRESS FIT BEARING D2611
AFTER PRIME

STAKE BEARING ~~4~~ PLACES
EACH SIDE

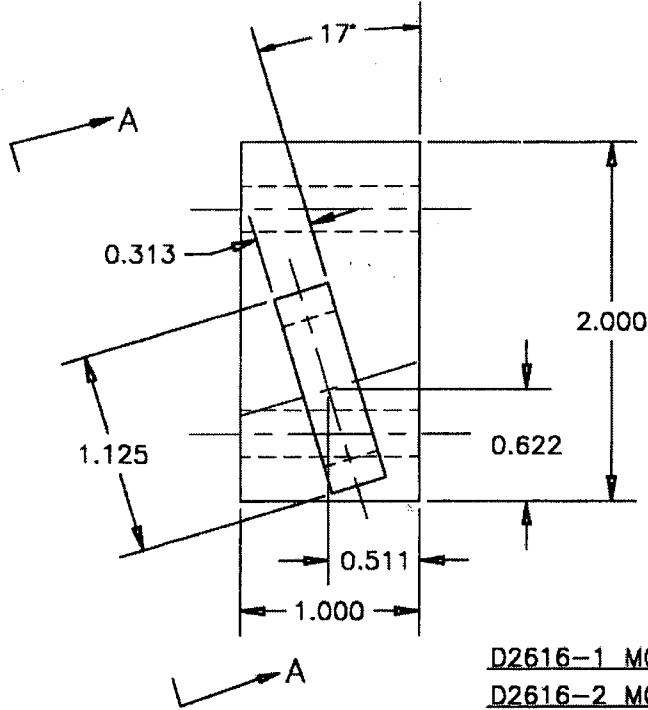
MASK BEARING PRIOR TO PAINT
LEAVE EDGES SHARP

0.625
1.259
RF
~~4~~ D2

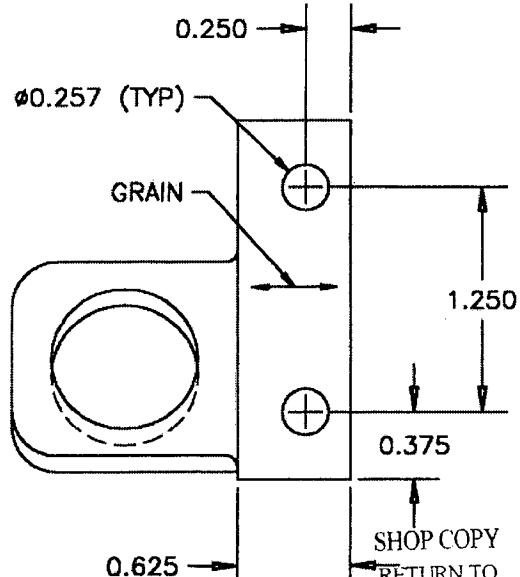
MATERIAL: 6061-T6 QQ-A-200/8
BREAK ALL SHARP CORNERS 0.010 TO 0.020
UNLESS OTHERWISE NOTED
FINISH: ACID ETCH, ALODINE PER QSI 005 4.1
PRIME PER QSI 005 4.2
OR PRIME, PAINT PER CUSTOMER SPEC
PER QSI 005 4.2

RELEASED
970731 BW

STAKING NOTES:
D2611 BEARING MUST BE STAKED TO PREVENT
TRANSLATION BUT TO STILL ALLOW ROTATION
USING DT8019. TOUCH UP PAINT AFTER STAKING.



D2616-1 MOUNTING LUG SHOWN
D2616-2 MOUNTING LUG OPPOSITE



UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

DART AEROSPACE LTD	Work Order:	27502
Description: FWD MOUNT LUG	Part Number:	D2646-1
Inspection Dwg: D2116 Rev: D		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article ✎ Prototype

Measured by:	<i>JW</i>	Audited by:	<i>JL</i>	Prototype Approval:	
Date:	01/06/25	Date:	06/06/25	Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

Date: Friday 28/09/2007 10:26:35 AM
 User: Linda Lacelle

Process Sheet

Customer	: CC-DAR01 Dart Aerospace Ltd.		Drawing Name	: D2616-1/-2/-3	
Job Number	: 34905		Part Number	: D26161	
Estimate Number	: 10804		Drawing Number	: NCR 230-REWORK	
P.O. Number	:		Project Number	:	
This Issue	: 28/09/2007	S.O. No. :	Drawing Revision	:	
Prsht Rev.	: NC		Material	:	
First Issue	: / /	Type : MACHINED PARTS	Due Date	: 05/10/2007 Qty: 146 Um: Each	
Previous Run	: 00015				
Written By	:				
Checked & Approved By	:				
Comment	:				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	PACKAGING 1	PACKAGING RESOURCE #1
		 Comment: PACKAGING RESOURCE #1
		PULL FROM STK: D2616-1B 14634 / B15818 (2 B# on bag) (Qty 54) already punch 4 Holes. { B27502 already punched 8 Holes (Qty 79)
	D2616-2 B	—
	D2616-3 B	—
2.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
		 Comment: SMALL & MEDIUM FAB RESOURCE 1
		x133 <i>ml 08/03/10</i>
3.0	PACKAGING 1	PACKAGING RESOURCE #1
		 Comment: PACKAGING RESOURCE #1
		RESTOCK USING SAME B/N <i>ST468 AS 08/03/11 X133</i>